

Date: Thursday, 02/10/2008 10:34:25 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE, OUTBOARD, LS, 206		
Job Number	: 42409			Part Number	: D26671		
Estimate Number	: 11011			Drawing Number	: D2667 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/10/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 25/10/2008		
Previous Run	:			Qty:			
Written By	:			Um:	Each		
Checked & Approved By	: JUL 08/10.02			10 AM.			
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: B34644 X9 B25348X1	JL 08/11/12
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on 08/11/11 by JL 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr	JL 08/11/12
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	JL 08/11/12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 10:34:25 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LS, 206

Job Number: 42409

Part Number: D26671

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JS 08/11/12

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

88 08/11/12

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08/11/17

7.0 POWDER COATING

POWDER COATING



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:30

1:30

OVEN TEMPERATURE: 320°

320°

FINISH TIME: 2:00

2:00

MF 08/11/17

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-12

(X10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST427

88 08/11/18 (X10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/18 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	4240A
Description: 206 Saddle, Outboard, Left side				Part Number:	D2667-1
Inspection Dwg: D2667 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.121	.121	.120		
B	0.100	0.140		.111	.113	.115	.115		
C	1.125	1.145		1.135	1.137	1.139	1.134		
D	0.615	0.685		.625	.625	.625	.625		
E	0.240	0.260		.252	.251	.252	.253		
F	1.313	1.343		1.327	1.327	1.328	1.327		
G	0.210	0.230		.219	.220	.220	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.492	2.492	2.492	2.492		
J	1.565	1.585		1.573	1.573	1.574	1.570		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.113	.113	.113	.112		
M	0.990	1.010		1.000	1.000	1.000	.999		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		5.999	6.001	6.000	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.320	.320	.320	.320		
T	1.995	2.005		2.000	2.000	2.000	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.797	.797	.797		
W	1.040	1.060		1.050	1.052	1.051	1.052		
X	1.674	1.679		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.921	.921	.921	.920		
AA	0.490	0.510		.499	.498	.499	.495		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	JL	Audited by:	88
Date:	08/11/11	Date:	08/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

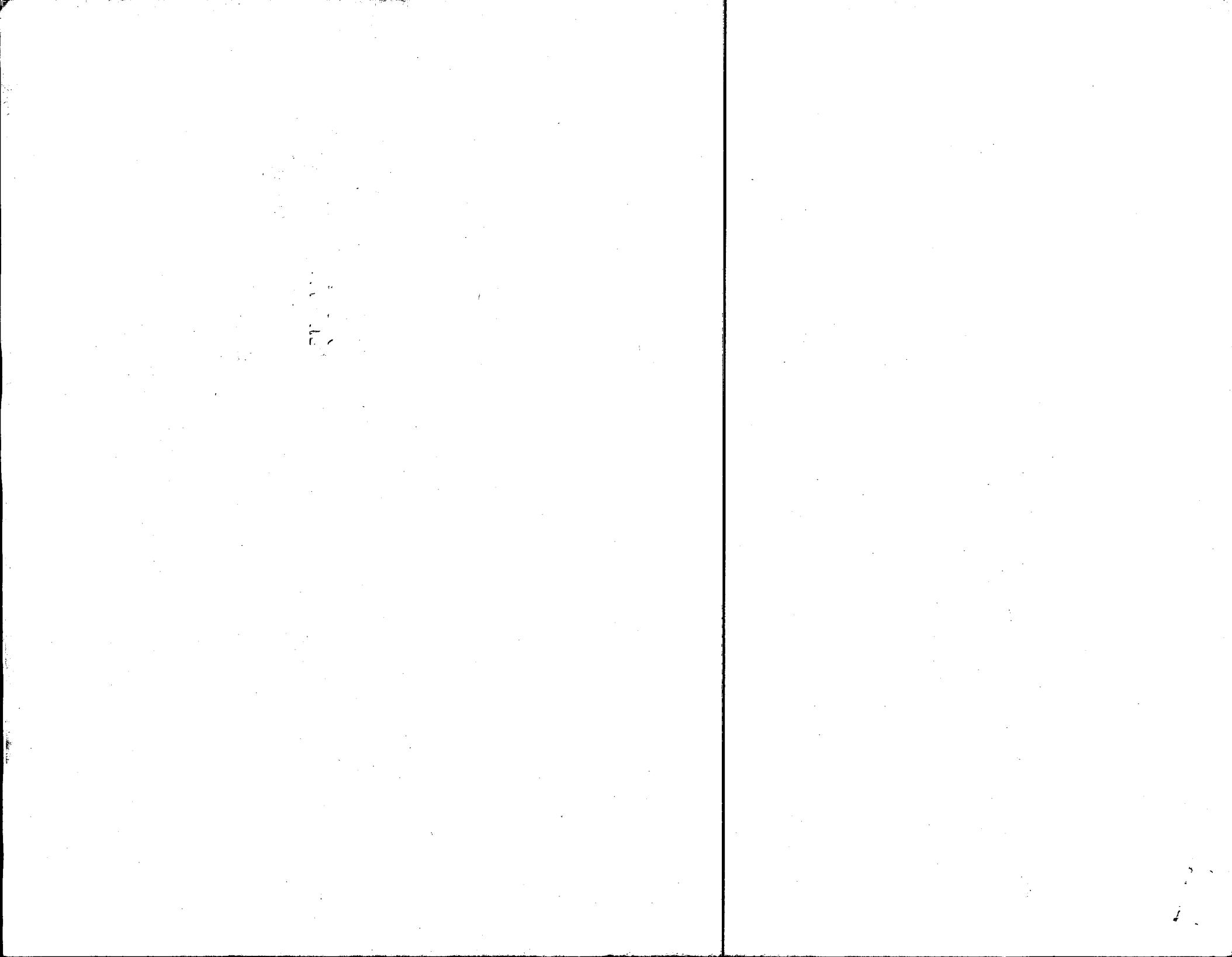
DART AEROSPACE LTD	Work Order:	42409
Description: 206 Saddle, Outboard, Left side	Part Number:	D2667-1
Inspection Dwg: D2667 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	.15	.26	.37	.48	By	Date
A	0.100	0.140		.121	.121	.122	.121		
B	0.100	0.140		.117	.116	.117	.117		
C	1.125	1.145		1.133	1.137	1.139	1.138		
D	0.615	0.685		.625	.625	.625	.625		
E	0.240	0.260		.254	.254	.250	.252		
F	1.313	1.343		1.327	1.327	1.328	1.327		
G	0.210	0.230		.219	.220	.221	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.492	2.492	2.492	2.492		
J	1.565	1.585		1.569	1.574	1.575	1.574		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.113	.113	.113	.113		
M	0.990	1.010		.999	.999	.999	.1000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.320	.320	.320	.320		
T	1.995	2.005		2.000	2.000	2.000	2.000		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797		
W	1.040	1.060		1.051	1.051	1.052	1.051		
X	1.674	1.679		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.921	.921		
AA	0.490	0.510		.499	.499	.499	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JL	Audited by:	BB
Date:	08/11/12	Date:	08/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	SP



DART AEROSPACE LTD

Work Order:

Description: 206 Saddle, Outboard, Left side

Part Number: D2667-1

Inspection Dwg: D2667 Rev. D

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

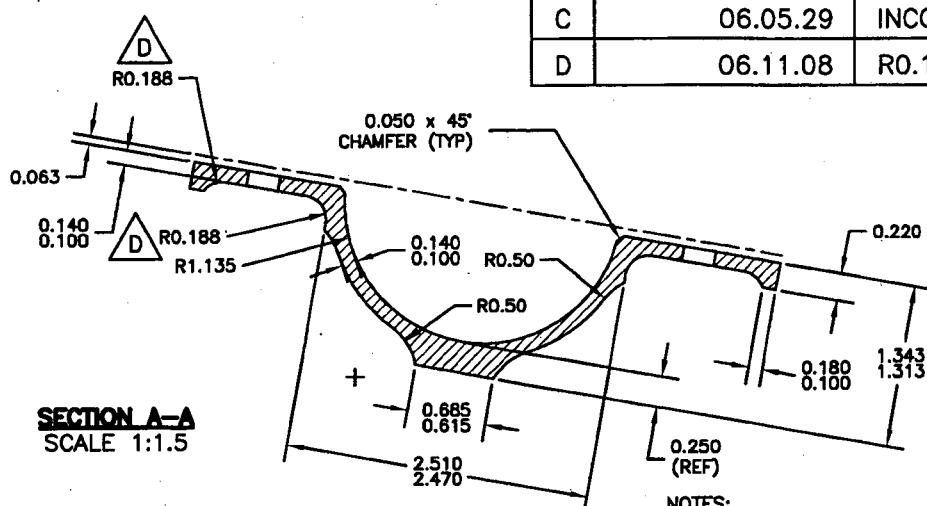
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	.79	.10	-3	-4	By	Date
A	0.100	0.140		.121	.120				
B	0.100	0.140		.117	.116				
C	1.125	1.145		1.137	1.138				
D	0.615	0.685		.625	.625				
E	0.240	0.260		.252	.252				
F	1.313	1.343		1.327	1.327				
G	0.210	0.230		.220	.221				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.492	2.492				
J	1.565	1.585		1.574	1.575				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.113	.113				
M	0.990	1.010		1.000	1.000				
N	0.510	0.515		.510	.510				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.314	.314				
S	0.315	0.322		.320	.320				
T	1.995	2.005		2.000	2.000				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.796	.797				
W	1.040	1.060		1.052	1.051				
X	1.674	1.679		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.921	.921				
AA	0.490	0.510		.500	.499				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: JL
Date: 08/11/12Audited by: JL
Date: 08/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	<u>JLM</u>
F	07.03.21	Revised per drawing revision D	KJ/JLM	<u>JLM</u>

DART

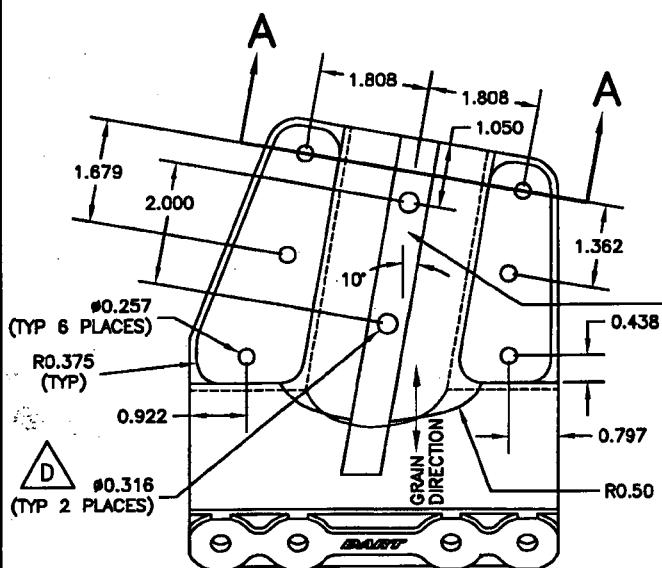
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	H	D2667
DATE		REV. D
06.11.08		SHEET 1 OF 1
		TITLE
		SCALE
		1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313



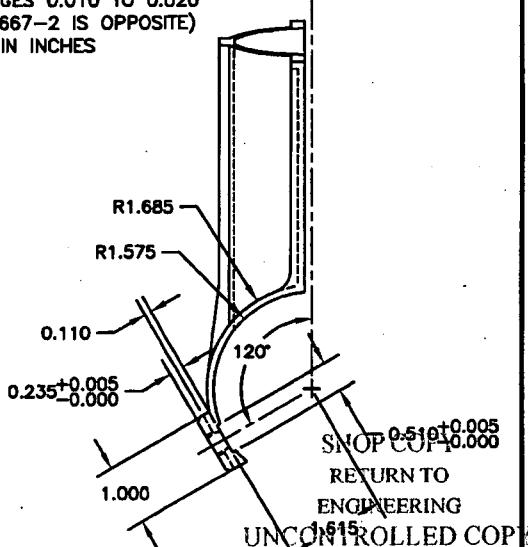
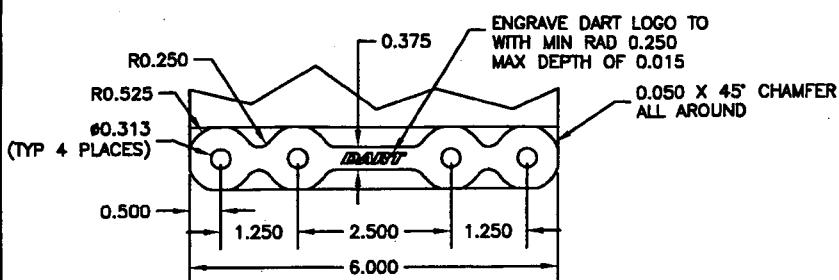
SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLT, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2667-1 SHOWN (D2667-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2667-1 SADDLE AFT OUTSIDE HIGH

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